

Date: Wednesday, 26/11/2008 12:46:02 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 43750					
Estimate Number	: 10175					
P.O. Number	:			Part Number	: D2570	
This Issue	: 26/11/2008	S.O. No.	:	Drawing Number	: D2570 REV B	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: / /	Type	: MACHINED PARTS	Drawing Revision	: B	
Previous Run	: 41638			Material	:	
Written By	:			Due Date	: 20/12/2008	
Checked & Approved By	: <u>JUL 08.11.26</u>			Qty:	500	Um: Each
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material change K J est F 07.07.06 rev B dwg EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M303R0750	303 Round Bar 0.750    <i>M110166 x 278 parts -&gt; 22.518</i>
		  <i>Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s) M107857 x 32parts -&gt; 2.592 f(s) -&gt; No more material Material: Ø0.750 AISI 303 SS Rod (M303R0.750) M108877 x 80 parts -&gt; (c. 480 f(s)) -&gt; No more material Batch: DTP 08/11/27 M108877 x 110 parts -&gt; 8.910 f(s) -&gt; No more material</i>
2.0	HARDINGE	HARDINGE CNC LATHE SMALL  
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE    <i>Comment: HARDINGE CNC LATHE SMALL Machine as per folio FA198 Deburr</i>  <i>222</i> <i>08/11/27</i>    <i>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</i>  <i>222</i> <i>08/11/27</i>    <i>Comment: SECOND CHECK</i>  <i>JL 08/12/09</i>
4.0	QC8	SECOND CHECK    <i>Comment: SECOND CHECK</i>  <i>JL 08/12/09</i>
5.0	PACKAGING 1	PACKAGING RESOURCE #1    <i>Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST37</i>  <i>18 08/12/11 6w</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 26/11/2008 12:46:02 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 43750

Part Number: D2570

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/15

Job Completion



MF 08-12-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	43750
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

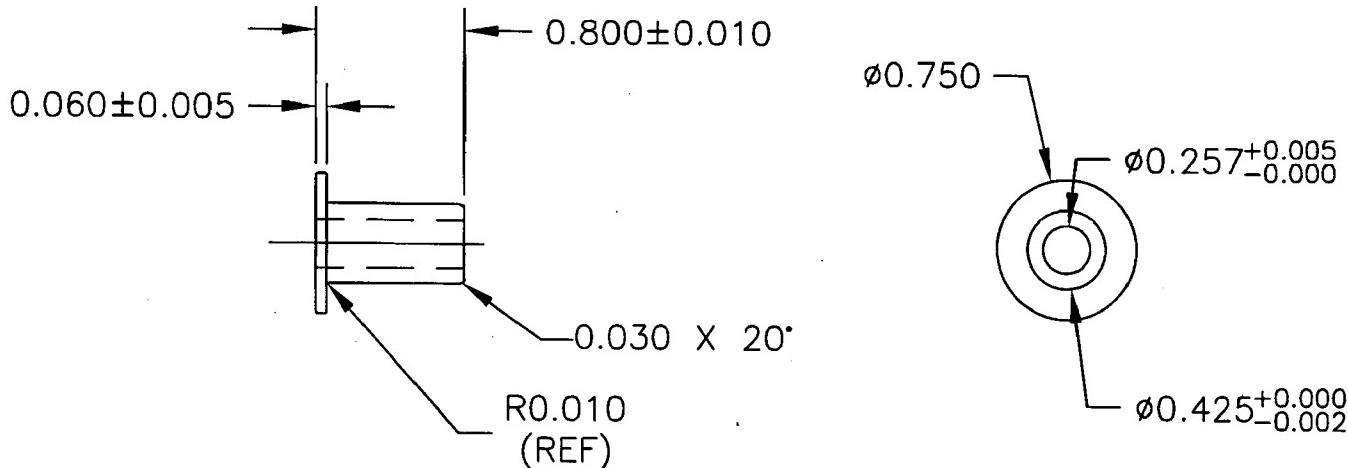
## X First Article      Prototype

Measured by:	DJP	Audited by:	JL	Prototype Approval:	N/A
Date:	08/11/09	Date:	08/12/09	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	
D	08.07.23	Tolerance for Ø0.257 revised	KJ/DD	

**DART**

DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

**RELEASED**  
07.06.28 *#***D2570 BUSHING****D2570 BUSHING**

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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